

1. A sheet metal can shell having a vertical center axis and a curled peripheral crown adapted to be double-seamed to an end portion of a formed sheet metal can body, said shell comprising a circular center panel connected by a curved panel wall to an inner wall of a countersink having a generally cylindrical outer wall and a U-shaped cross-sectional configuration, a generally frusto-conical chuckwall extending from said outer wall of said countersink and having an inclined upper wall portion extending at an angle of at least 16° relative to said center axis and an inclined lower wall portion, said chuckwall having a slightly S-curved intermediate wall configuration, said crown having an inner wall connected to said chuckwall at a first junction, said countersink having a radius of curvature substantially smaller than a radius of curvature of said curved panel wall, and said countersink having a width between said inner and outer walls of said countersink less than said radius of curvature of said panel wall.
2. A shell as defined in claim 1 wherein said lower wall portion of said chuckwall connects with said outer wall of said countersink at a second junction disposed substantially below the level of said center panel.
3. A shell as defined in claim 2 wherein the difference in diameters between said inner wall of said crown at said first junction and said outer wall of said countersink at said second junction is greater than said width of said countersink.
4. A shell as defined in claim 1 wherein said width of said countersink is less than .035 inch.
5. A shell as defined in claim 1 wherein said inclined upper wall portion of said chuckwall extends at an angle between 25° and 35° relative to said center axis.
6. A shell as defined in claim 1 wherein said inner wall of said countersink extends at an angle of about 40° relative to said center axis.

7. A shell as defined in claim 1 wherein said inclined lower wall portion of said chuckwall extends at an angle less than said angle of said upper wall portion and relative to said center axis.
8. A shell as defined in claim 1 wherein said inner wall of said countersink extends at an angle greater than said angle of said inclined lower wall portion of said chuckwall and relative to said center axis.
9. A shell as defined in claim 1 wherein said lower wall portion of said chuckwall connects with said outer wall of said countersink at a second junction, and the axial distance between said first and second junctions is substantially greater than said width of said countersink.
10. A shell as defined in claim 1 wherein said countersink has a first curved corner portion connected to said curved panel wall and a second curved corner portion connected to said outer wall of said countersink, and said first curved corner portion has a radius of curvature larger than a radius of curvature of said second curved corner portion.
11. A sheet metal can shell having a vertical center axis and a curled peripheral crown adapted to be double-seamed to an end portion of a formed sheet metal can body, said shell comprising a circular center panel connected by a curved panel wall to an inner wall of a countersink having a generally cylindrical outer wall and a U-shaped cross-sectional configuration, a generally frusto-conical chuckwall extending from said outer wall of said countersink and having an inclined upper wall portion extending at an angle of at least 16° relative to said center axis, said crown having an inner wall connected to said upper wall portion of said chuckwall at a first junction, said chuckwall having an inclined lower portion connected to said outer wall of said countersink at a second junction disposed substantially below the level of said center panel, said countersink having a radius of curvature substantially smaller than a radius of curvature of said curved panel wall, and the width of said countersink between said inner and outer walls of said countersink being less than said radius of curvature of said panel wall.

12. A shell as defined in claim 11 wherein the difference in diameters between said inner wall of said crown at said first junction and said outer wall of said countersink at said second junction is greater than said width of said countersink.
13. A shell as defined in claim 11 wherein said upper wall portion of said chuckwall extend at an angle of at least 25° relative to said center axis.
14. A shell as defined in claim 11 wherein said chuckwall has a slightly S-curved intermediate wall configuration.
15. A sheet metal can shell having a vertical center axis and a curled peripheral crown adapted to be double-seamed to an end portion of a formed sheet metal can body, said shell comprising a circular center panel connected by a curved panel wall to an inner wall of a countersink having a U-shaped cross-section, a generally frusto-conical chuckwall including an upper wall portion extending at an angle greater than 16° relative to said center axis, said crown having an inner wall connected to said upper wall portion of said chuckwall at a first junction, said chuckwall having an inclined lower wall portion connected to an outer wall of said countersink at a second junction, said countersink having a radius of curvature substantially smaller than a radius of curvature of said curved panel wall, said second junction being spaced below the level of said center panel, and the axial distance between said first junction and said second junction being greater than a radial width of said countersink between said inner and outer walls of said countersink.
16. A shell as defined in claim 15 wherein the difference in diameters between said inner wall of said crown at said first junction and said outer wall of said countersink at said second junction is greater than said width of said countersink.
17. A shell as defined in claim 15 wherein said upper wall portion of said chuckwall extends at an angle of at least 25° relative to said center axis.
18. A shell as defined in claim 15 wherein said inner wall of said countersink extends at an angle of about 40° relative to said center axis.

19. A shell as defined in claim 15 wherein said curved panel wall has a radius of curvature substantially greater than said width of said countersink.